

Work Order ID 155419

Friday, January 13, 2017 11:08:40 AM

155419

Page 1

Item ID: D2804-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: RH Step Fwd Bracket
 Start Date: 1/13/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/27/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 1-1-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2804	D								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.02							
Small Fab	Press D2805-2 and D2809 into arm as per Dwg D2804								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	Grey Sandtex(Ref 43.5.6) per OSI005 4.3	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>8:10</u> OVEN TEMPERATURE:								
	FINISH TIME: <u>8:40</u>								

DAS
36
9-89

DAS
36
9-89

FEB 02 2017

DAS
34
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

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130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>2</u>			DAS 38 9-89 FEB 07 2017
150 *150* Small Fab Small Fab	Small Fab Memo 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.	0.00 0.04				<u>2X</u>			DAS 36 9-89 17/01/17
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>2</u>			DAS 38 9-89 FEB 08 2017

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>1/10</i>	0.00				<i>2x</i>			<i>17/02/08</i>
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							<i>17/2/9</i>
180									
QC	Memo	0.03							
Quality Control									

DAS
21
9-89

FEB 08 2017

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OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 155419

155419

Parent Item: D2804-042

D2804-042

Parent Item Name: RH Step Fwd Bracket

Start Date: 1/13/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM
IPP REV:H 16.06.23 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2 *D2804-2* Bracket		Manufactured	No			100	Each	4.0000	1	2		17/02/01	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST475				4					B151888 (1x)
				146642				4					B129998 (1x)
D2805-2 *D2805-2* Stop		Manufactured	No			100	Each	12.0000	1	2		17/02/01	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST010				12					
				149476				12		2			
D2809 *D2809* Washer		Manufactured	No			100	Each	29.0000	1	2		17/02/07	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				4					
				130466				1					
				146514				2					
				149434				1					
				ST011				25					
				138750				14					
				34035				11					B156588 (2x)

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 155419

155419

Parent Item: D2804-042

D2804-042

Parent Item Name: RH Step Fwd Bracket

Start Date: 1/13/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

AN3C16A Purchased No

150 Each 29.0000 2 4

AN3C16A

BOLT

**

17/02/07

DAS
36
9-89

Location

Loc Qty

Loc Code

ST348

29

m135704

29

D3672-15 Manufactured No

150 Each 271.0000 4 8

D3672-15

Phenolic Washer

**

17/02/07

DAS
36
9-89

Location

Loc Qty

Loc Code

ST049

21

149430

21

ST051A

250

151784

250

MS21043-3 Purchased No

150 Each 1,152.000 2 4

MS21043-3

Nut

**

17/02/07

DAS
36
9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

403

m130673

11

m136182

392

GA

415

m133990

27

m136295

388

ST302

185

m135864

185

ST304

69

m131340

69

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Shop Packet Print

Page 2

DQA: _____ Date: _____

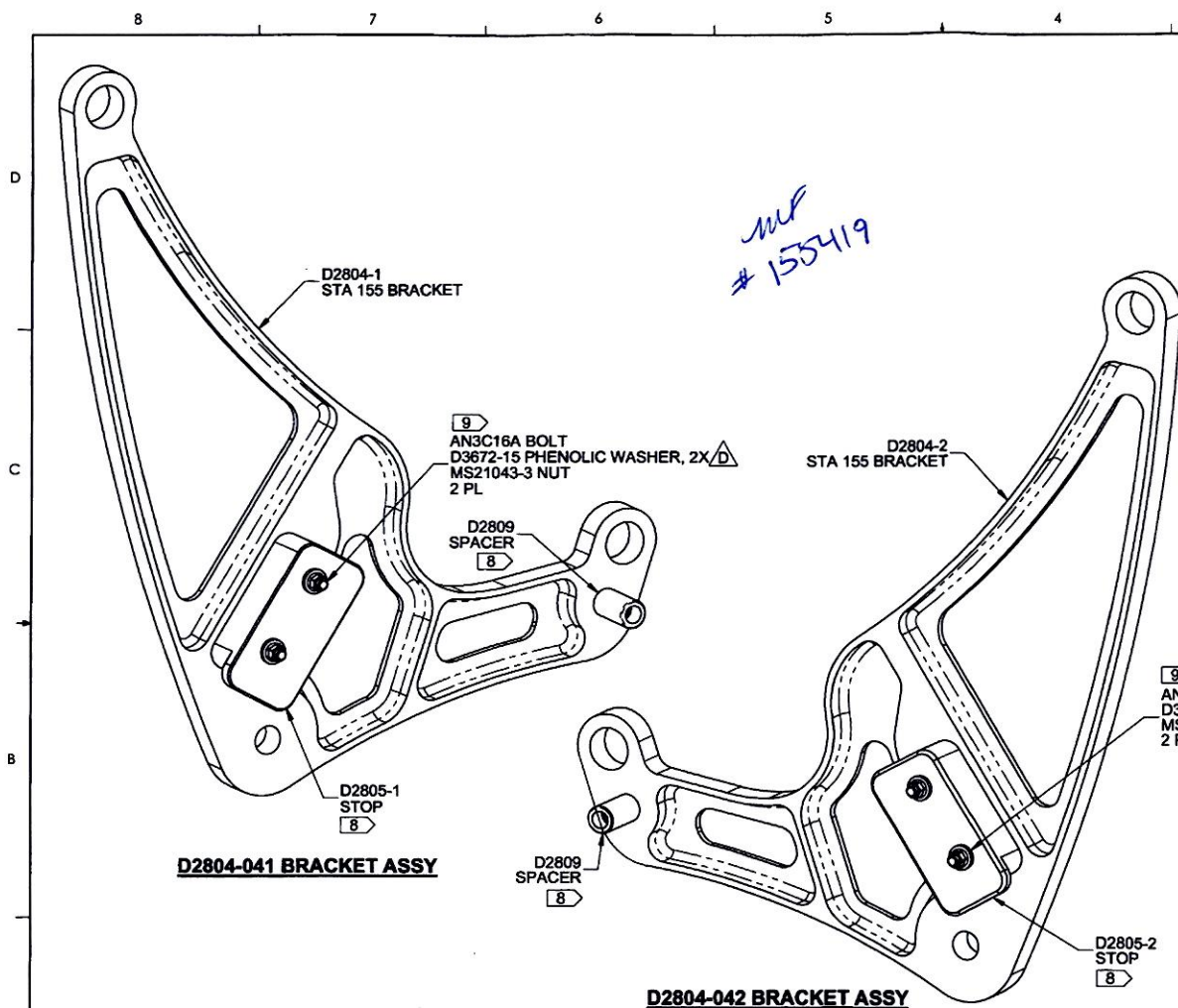


WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2804-041	BRACKET ASSY
		X	D2804-042	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING

RELEASED

2016 JUN 22
ECN 16-66

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDEXT" (4.3.5.6) OR "BLACK SANDEXT" (4.3.5.7) OR "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.37 lbs
- 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
- 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

D	REVISE TO CURRENT FORMAT: D3672-15 WAS NAS1515H3; MS21043-3 WAS MS21042-3; ADD CSINK (SECTIONS E-E AND J-J). REF: PAR16-499. D6-3/4: 2.656 WAS 2.654 REASON: CAD ERROR.	MB	16.04.11
C	CHANGE GEOMETRY TO ADD CLEARANCE	CP	06.10.16
B	ADD CUTOUPS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 155 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
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